Qty:

User This Issue Prsht Rev. First Issue Previous Run Written By Comment

Wednesday, 3/7/2007 3:52:43 PM

: NA

: 30816

Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Job Number : 31068 : 10725 **Estimate Number**

: N/A P.O. Number

S.O. No. : 1) : 3/7/2007 : NC

: MACHINED PARTS

Part Number **Drawing Number**

Drawing Name

: D2652 : D2652 REV A : N/A

: BUSHING

Project Number **Drawing Revision** Material

: 3/30/2007

300 Um:

Each

Checked & Approved By

: Est Rev:B 2.06.13

Now machined in house.

NG

Due Date

Additional Product

Job Number:



Seq. #: 1.0 M303R0500

Description: Machine Or Operation:

303 Round Bar 0.500"

Comment: Qty.:

17.3250 f(s) 0.0578 f(s)/Unit Total:

Material:303 ss .500" Round Bar

(M303R0500)

Batch: M 108447

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA250 & Dwg D2652

2-Deburr

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:



17-05.17

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | | | | |
|---------|------|------------------------|----------|-------|---------------|-------------------------------------|--------------------------|--|--|--|
| DATE | STEP | PROCEDURE CHANGE | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | | | |
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| | | | | | | | | | | |
| Part No | • | PAR #· Fault Category: | NCR: Yes | No Do | A · /S | Date: 6 | 17/05/18 | | | |

QA: N/C Closed: ____ Date: ____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | | |
|------|------|----------------------------------|----------------------|------------------------------|----------------|---------------------------|-----------------------|--------------------------|--|--|
| | | Description of NC | | Corrective Action Section B | | | Approval | T | | |
| DATE | STEP | Section A | Initial Chief Eng | Action Description Chief Eng | Sign & Date | Verification Section C | Approval Chief Eng | Approval QC Inspector | | |
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NOTE: Date & initial all entries

Date:

Wednesday, 3/7/2007 3:52:43 PM

Uзer:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 31068

Part Number: D2652

Job Number:



Seq. #: `

Machine Or Operation:

Description:

6.0

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | | | | |
|---------|------|-----------------------|----------|-------|-----|-------------------------------------|--------------------------|--|--|--|
| DATE | STEP | PROCEDURE CHANGE | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | | | |
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| Part No | | DAP #· Fault Catogogy | NCP: Vos | No DO | Λ. | Data | | | | |

QA: N/C Closed: ____ Date: ____

| | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | | |
|------|----------------------------------|----------------------------------|------------------------------|---|--|--|--|--|--|
| | Description of NC | Corrective Action Section B | | | Varification A | A | | | |
| STEP | Section A | Initial Chief Eng | Action Description Chief Eng | Sign & Date | Section C | Chief Eng | Approval QC Inspecto | | |
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| | STEP | STEP Description of NC Section A | STEP Section A Initial | STEP Section A Initial Action Description | STEP Section A Initial Action Description Sign & | STEP Section A Initial Action Description Sign & Section C | STEP Section A Initial Action Description Sign & Verification Approval | | |

NOTE: Date & initial all entries

| DART AEROSPACE LTD | Work Order: | 31068 |
|------------------------------|--------------|-------------|
| Description: Bushing | Part Number: | D2652 |
| Inspection Dwg: D2652 Rev: A | | Page 1 of 1 |

| Inspection Dwg | : D2652 Re v | v: A | | | | Page 1 of 1 |
|----------------|---------------------|--------------|----------|---------------|----------------------|-----------------|
| | | ST ARTICLE I | NSPECTI | ON CHE | CKLIST | |
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| Drawing | Tolerance | Actual | Accept | Reject | Method of Inspection | Comments |
| Dimension | | Dimension | | | mspection | |
| 0.600 | +/-0.010 | ,600 | / | | | |
| 0.060 | +/-0.005 | ,0303 | / | | | |
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| Measured by: | 8,8 | Audited by: | En | P | Prototype Approv | al: N/A |
| Date: z | 7/00/15 | Date: | 0765/1 | 5 | Da | te: |
| Rev Date | Change | | | | Ravis | sed by Approved |

| Meas | ured by: | 8.18 | Audited by: | En | Prototype A | pproval: | N/A |
|------|----------|-----------|-------------|----------|-------------|-----------|------------|
| | Date: | 7/00/15 | Date: | 07/05/15 | | Date: | |
| Rev | Date | Change | | | | Revised b | y Approved |
| Α | 03.12.12 | New Issue | | | | KJ/RF | + 4 |
| | | • | | | | • (| .) |
| | | | | | | | |





| DESIGN | DRAWN BY |
|---------|----------|
| CHECKED | APPROVED |

DART AEROSPACE USA, INC.
FAIRCHILD INTERNATIONAL AIRPORT, WA
DRAWING NO.
REV.

D2652

REV. A

- | 10·M

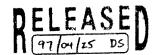
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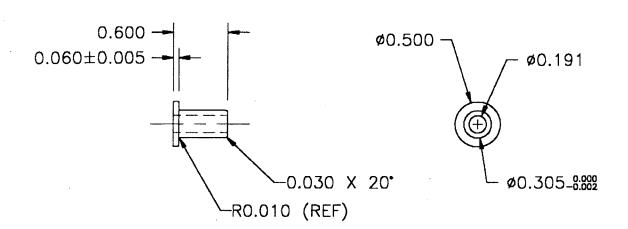
TEE! I UF

97:03:25

BUSHING

1:1





MATERIAL: AISI 303 SS

NOTE: BREAK ALL SHARP CORNERS 0.010 MAX

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER NO. 31068